

ASAP

**Work Order ID 71797**

Tuesday, July 12, 2011 9:57:20 AM

Page 1

Item ID: D3798-042

Accept

Revision ID:

Item Name: Spacepod Floor

Start Date: 7/12/2011 Start Qty: 2.00

Required Date: 7/13/2011 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3798

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3798-2

\*\*\*same flat paterne as D3798-1\*\*\*

Dwg Rev: B

Prog Rev: B

2-Deburr if necessary

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

\*\*\*template D3798-1T1\*\*\*

181-7-12

(2)

181-7-12

# Work Order ID 71797

Tuesday, July 12, 2011 9:57:20 AM



Page 2

Item ID: D3798-042

Revision ID:

Item Name: Spacepod Floor

Start Date: 7/12/2011 Start Qty: 2.00

Required Date: 7/13/2011 Req'd Qty: 2.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan: Date:

QC: Date:

Tooling: Date:

SPC (Y/N): Date:

Run Start



Stop



Sequence ID/  
Work Center ID

120



QC

Quality Control

Operation  
Description

QC8- Inspect parts - second check

Memo

\*\*\*template D3798-IT1\*\*\*

Set Up/  
Run Hours

0.00

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

5/10/12

2

130



Small Fab

Small Fab

Memo

1- C'sink as per dwg D3798-2

2- Deburr if necessary

0.00

0.00

5/10/12 2

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

11 07 12 2

# Work Order ID 71797

Tuesday, July 12, 2011 9:57:20 AM



Page 3

Item ID: D3798-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Floor

Start Date: 7/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

2  $\phi$  BR 11-7-13.

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2x  $\phi$  M-L 11/07/13

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble D3798-2 to D3798-5 as per dwg

ES 11/07/13 (2x)

# Work Order ID 71797

Tuesday, July 12, 2011 9:57:20 AM



Page 4

Item ID: D3798-042

Revision ID:

Item Name: Spacepod Floor

Start Date: 7/12/2011 Start Qty: 2.00

Required Date: 7/13/2011 Req'd Qty: 2.00

Reference:

Approvals: Process Plan: Date:

QC: Date:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop



Tooling: Date:

SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

*5 units*

QC

Memo

0.00

Quality Control



*042*

190

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Powdercoat

Powder Coating

Memo

POWDER COAT:

Start Time:

Oven Temperature:

Finish Time:

0.00

*11:30*  
*3200F*  
*12:00*

*2x Ø M-F 4/07/13*

200

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

*26 M 4/07/13*

*M115128*

Tuesday, July 12, 2011 9:57:20 AM

Page 5

**Accept**



**Setup Start**

**Stop**

11  
12  
13  
14  
15  
16  
17  
18  
19  
20  
21  
22  
23  
24  
25

[illegible]**Cust Item ID:**

**Customer:**

**Reference:**

Date:

**Tooling:**

Date:

Run Start

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

## Set Up/ Run Hours

210

0,00

## Small Fab

## Memo

0.00

## Small Fab

1-Install foam as per dwg D3798 using contact cement

A/R Contact Cement batch: 112983

2- Trim foam if necessary

220

QC5- Inspect part completeness to step on W/O

0.00

QC

## Memo

0.00

## Quality Control

230

Identify as per dwg & Stock Location: 241A 0.00

0.00

### Packaging

## Memo

0.00

## Packaging

# Work Order ID 71797

Tuesday, July 12, 2011 9:57:20 AM



Page 6

Item ID: D3798-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Spacepod Floor

Start Date: 7/12/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 7/13/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start



QC: Date:

SPC (Y/N): Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/14  
ME 11-07-14

# Picklist Print .

Tuesday, July 12, 2011 9:57:17 AM

Page 1

Work Order ID: 71797

Parent Item: D3798-042

Parent Item Name: Spacepod Floor

Start Date: 7/12/2011

Required Date: 7/13/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-09-18 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.050		Purchased	No			100	sf	179.0000	8.794	18.51368			



6061-T6 .050 Sheet

Location Loc Qty Loc Code

MAT021	179	
113216	19	
114799	128	
114993	32	

D3798-5	Manufactured	No	170	Each	14.0000	1	2
---------	--------------	----	-----	------	---------	---	---



Reinforcement

Location Loc Qty Loc Code

ST241A	14	
55053	14	

MS20426AD4-	Purchased	No	170	Each	4,257.000	33	66
-------------	-----------	----	-----	------	-----------	----	----



Rivet

Location Loc Qty Loc Code

ST317	4257	
113064	4257	

D3798-3	Manufactured	No	210	Each	5.0000	1	2
---------	--------------	----	-----	------	--------	---	---



Spacepod Floor Foam

Location Loc Qty Loc Code

ST242	5	
51098	1	
53904	4	

B(1-7-17

7

114799

7/12/14

7/12/13

11/16/88 (660)

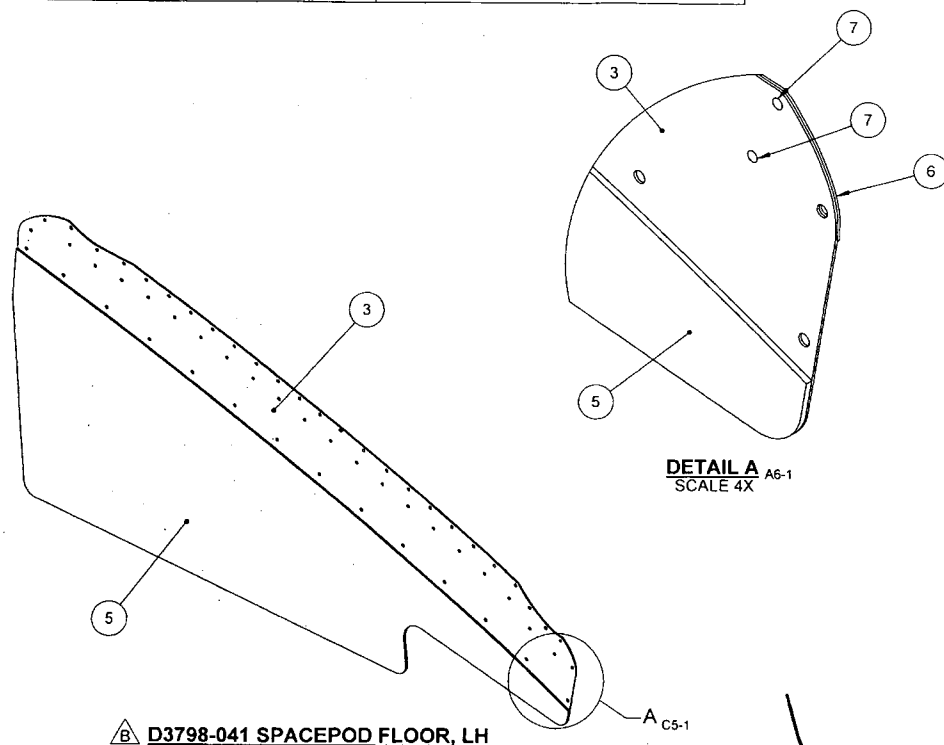
11-07-14

x2

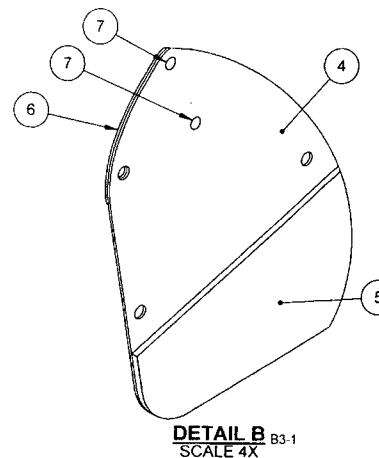




ITEM NO.	QTY. -041	QTY. -042	PART NUMBER	DESCRIPTION
1	X		D3798-041	SPACEPOD FLOOR ASSEMBLY, LH
2		X	D3798-042	SPACEPOD FLOOR ASSEMBLY, RH
3	1		D3798-1	SPACEPOD FLOOR
4		1	D3798-2	SPACEPOD FLOOR
5	1	1	D3798-3	SPACEPOD FLOOR FOAM
6	1	1	D3798-5	REINFORCEMENT
7	33	33	MS20426AD4-3	RIVET



**D3798-041 SPACEPOD FLOOR, LH**



**D3798-042 SPACEPOD FLOOR, RH**

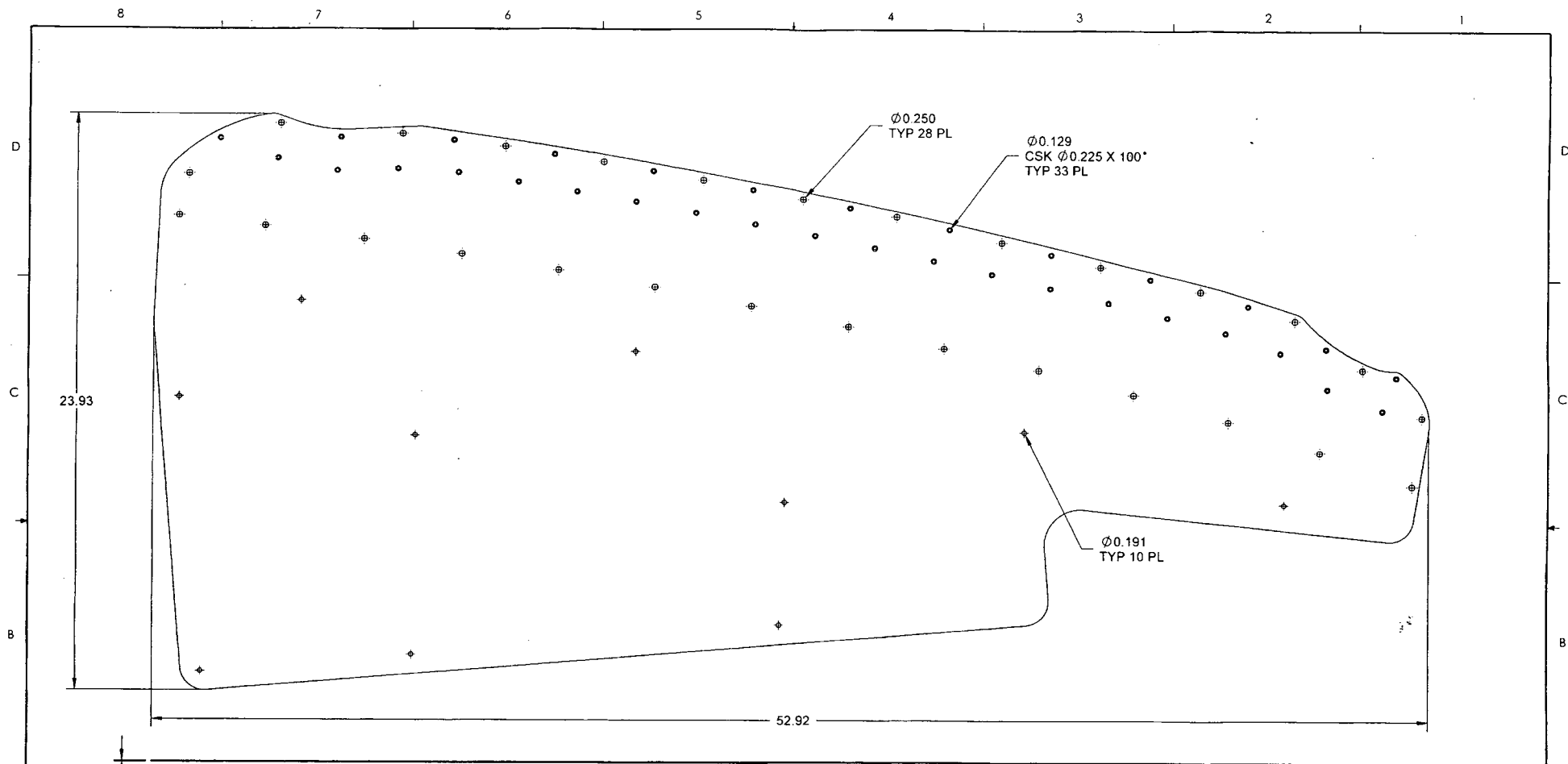
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3798-041/-042 USING WHITE FINE POINT PERMANENT MARKER
- 7) WEIGHT: D3798-041 - 5.0 lbs  
D3798-042 - 5.0 lbs
- 8) ASSEMBLY INSTRUCTIONS
  - RIVET D3798-5 REINFORCEMENT TO D3798-1/-2 SPACEPOD FLOOR USING RIVETS AS INDICATED
  - POWDER COAT PER NOTE 2
  - INSTALL D3798-3 FOAM AS INDICATED USING CONTACT CEMENT. TRIM TO FIT.

B	ADD -5 (SHEET 4); REVISE -041/-042; ADD ASSEMBLY INSTRUCTIONS (NOTE 8)	HS	09.10.08
A	NEW ISSUE	HS	08.10.20
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3798</b>	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		<b>SPACEPOD FLOOR</b>	NTS
DATE	09.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

**RELEASED**  
2009-10-13

*Handwritten signature/initials*

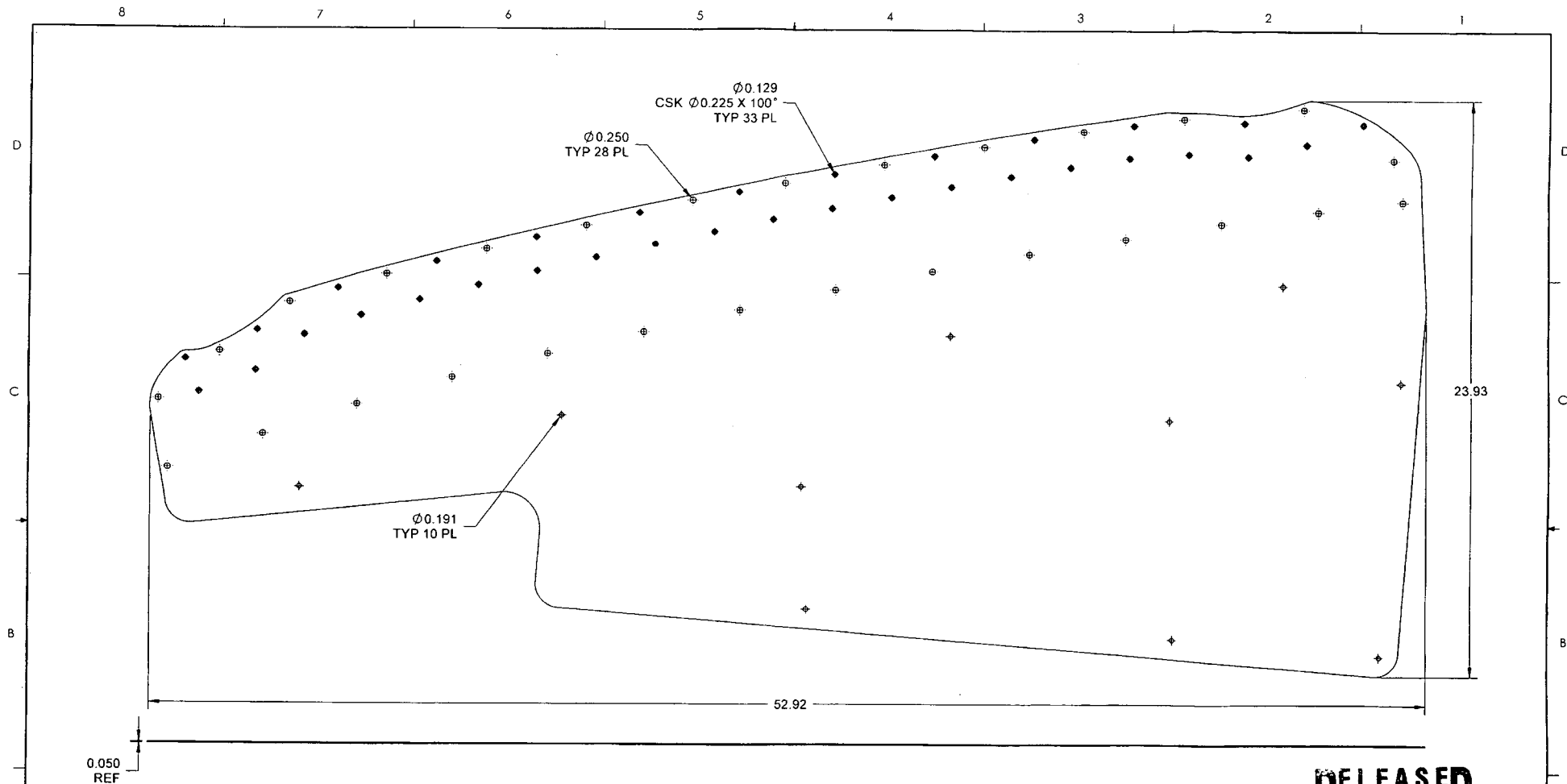


**D3798-1 SPACEPOD FLOOR**

**RELEASED**  
2009-10-13

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 4.0 lbs
  - 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3798-2 SPACEPOD FLOOR**

**RELEASED**  
2009-10-13

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.0 lbs
- 8) CONTROL PART PER TEMPLATE DT9432

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3798	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		SPACEPOD FLOOR	NTS
DATE	09.10.08	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

